

Work Order ID 135321***135321***

Page 1

Wednesday, August 12, 2015 11:51:52 AM

Item ID: D3916-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Rib Assembly
Start Date: 8/12/2015 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 8/12/2015 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: MLS Date: AUG 12 2015 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3916	A								

100

0.00

100

Large Fab

Memo

0.00

Large Fab

- 1- Cut tube 50"
2- Bend tube with manuel pipe bender as per DT9567
*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***
3- Trim access tube material to finish size as per dwg D3916
4- Drill and chamfer holes as per dwg D3916-1 using DT9605

8x CL 15-8-17

105

QC6- Inspect dimensions to drawing

0.00

105

QC

Memo

0.00

Quality Control

DAS
43
9-898xAUG 18 2015

Work Order ID 135321

Wednesday, August 12, 2015 11:51:52 AM

135321

Page 2

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QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
107	Weld per dwg A/R S.S. rod Batch: 3132768	0.00							
107									
Large Fab	Memo	0.00							
Large Fab	1- weld bushing as per dwg D3916 2- grind welds flush								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC10- Inspect visual per QSI004- ground welds	0.00							
120									
QC	Memo	0.00							
Quality Control									

8x CC 15-8-19

8 AUG 19 2015 DAS 24 9-59

8 AUG 19 2015 DAS 24 9-59

Work Order ID 135321

Wednesday, August 12, 2015 11:51:52 AM

135321

Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>WA4</u>	0.00				8		AUG 19 2015	DAS 24 9-89
130									
Packaging	Memo	0.00							
Packaging	LOCATION: WA004								
140	QC21- Final Inspection - Work Order Release	0.00						AUG 19 2015	
140									
QC	Memo	0.00							
Quality Control									

ms AUG 19 2015
SO 20150819

Picklist Print

Wednesday, August 12, 2015 11:51:56 AM

Page 1

Work Order ID: 135321

135321

Parent Item: D3916-041

D3916-041

Parent Item Name: Rib Assembly

Start Date: 8/12/2015

Required Date: 8/12/2015

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP RevA: New issue DD verified by:EC
per dwg revA 10.03.15 verified by:EC

IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3759-1

Manufactured No

100

Each

147.0000

7

56

D3759-1

Bushing

**

CC 15-8-18

Location

Loc Qty

Loc Code

WA004

147

116816

59

117449

2

132468

18

132855

8

133406

40

133917

20

4x

32x

20x

M304TS0.750W.049

Purchased

No

100

f

1,051.559

4.166

35.08211

M304TS0 750W 049

304 SQ Tube .75x.75x.049W

**

CC 15-8-17

Location

Loc Qty

Loc Code

WA004

1051.5594

M130871

50.4

M131128

18.175

M131868

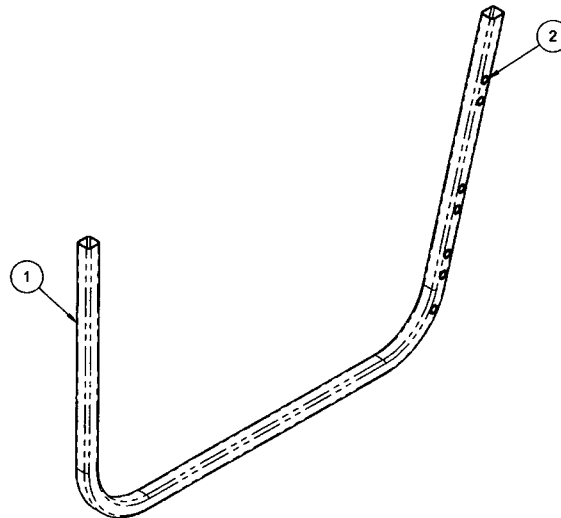
393.5

M132744

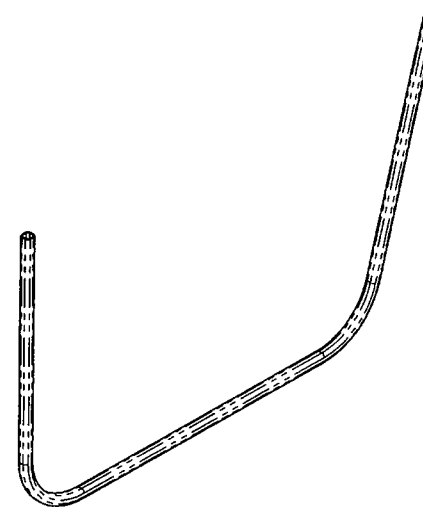
589.4844

36

ITEM	QTY	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



D3916-041 RIB ASSY



D3916-5 LIGHT RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 135321 ML5
15-08-12

OL 10.12.21
UNDER REVIEW
10.10.11

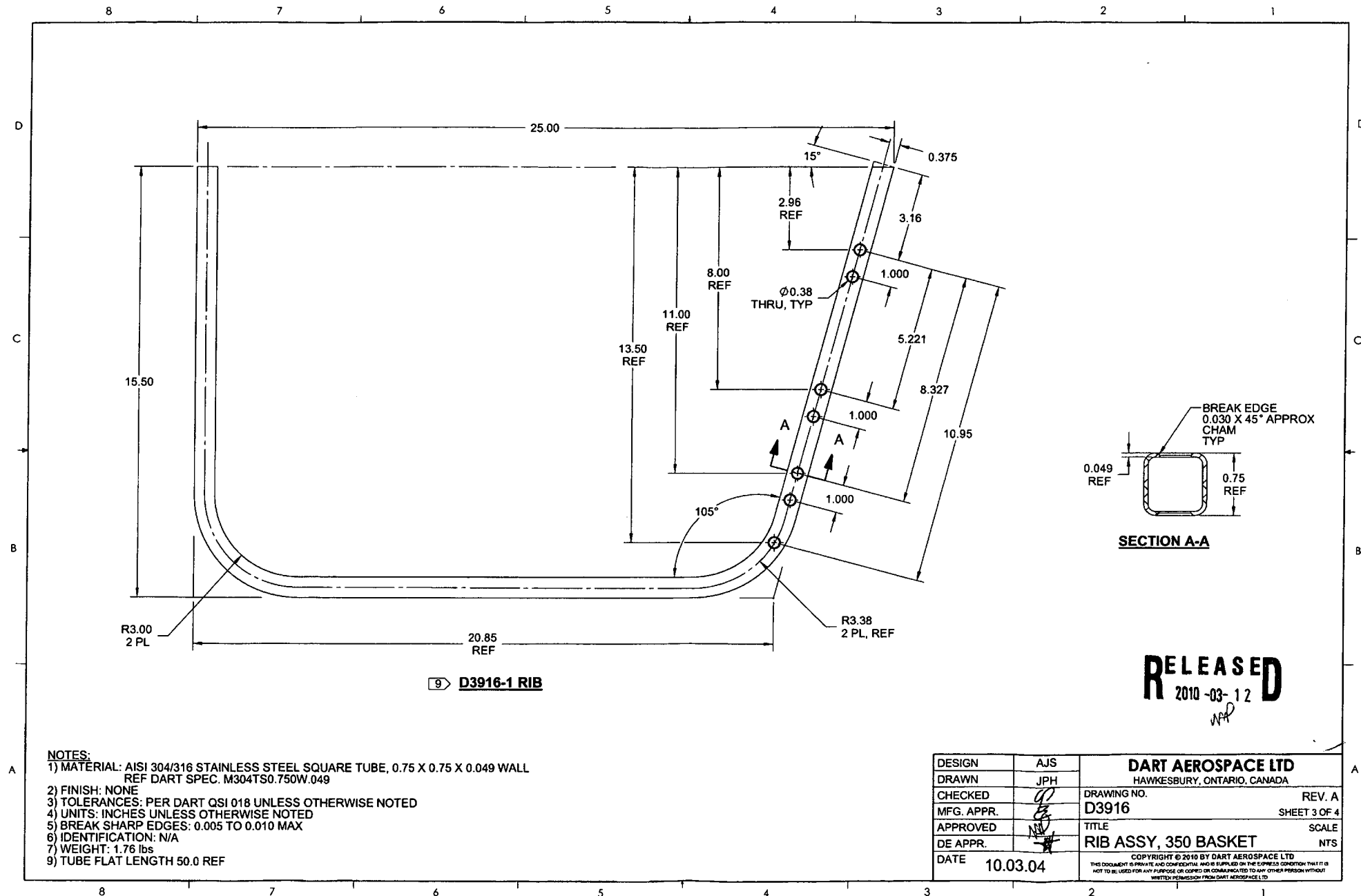
ADDITION OF HOLE + BUSHING
ON D3916-041 RIBS.

RELEASED
2010-03-12
JWP

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	JPH		
CHECKED	[Signature]		
MFG. APPR.	[Signature]		
APPROVED	[Signature]		
DE APPR.	[Signature]		
DATE	10.03.04		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3916	REV. A SHEET 1 OF 4
TITLE RIB ASSY, 350 BASKET	SCALE NTS

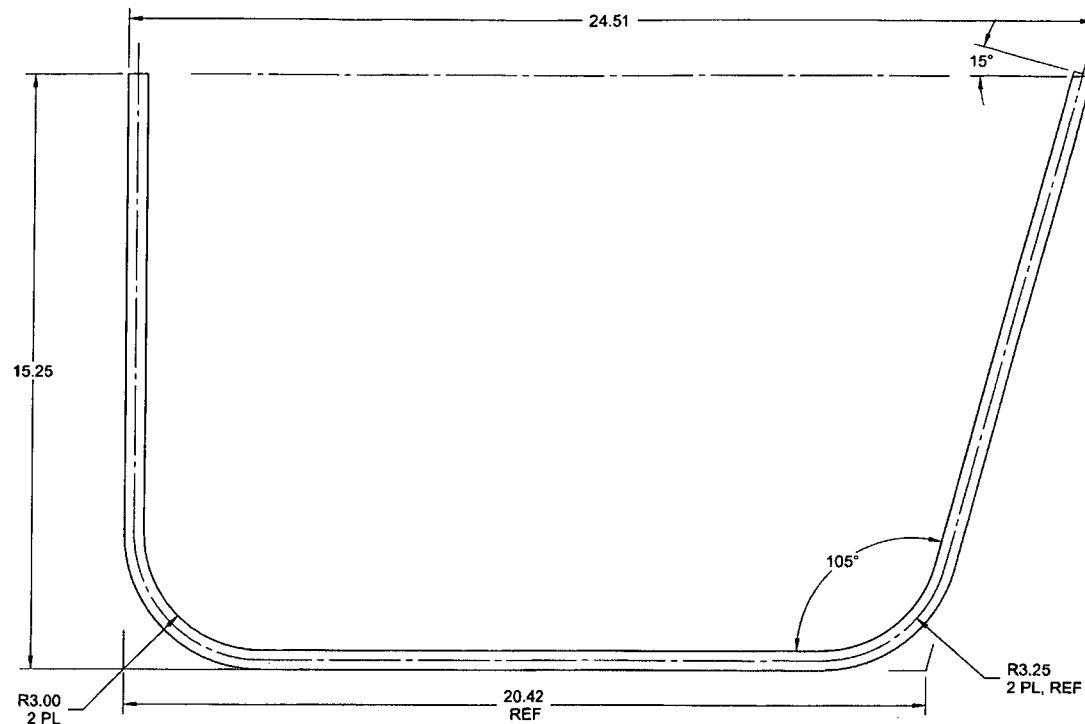
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NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3916	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY, 350 BASKET	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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9 D3916-5 LIGHT RIB

RELEASED
2010-03-12
JNP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3916	REV. A SHEET 4 OF 4
MFG. APPR.	<i>[Signature]</i>	TITLE RIB ASSY, 350 BASKET	SCALE NTS
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